



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

→ D206-547-043
Job Sheet 196739



Part No: D206-547-043

Job Qty: 2 pcs

Part Name: Console High Slope



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 7/26/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D206-547 REV F IPP Rev: I 06-01-05 Removed Packing Kit JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs			
100	Small Fab - 1	2 pcs	7/26/19		0.00	2.14	Small Fab - 1		DAS 58 OCT 18 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	2 pcs	7/26/19		0.00	2.14	Small Fab - 1 - B4B		DAS 58 OCT 18 2019
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 5	2 pcs	7/26/19		0.00	0.00	QC 5 - 10		EL
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		



Container No: S223925



Part: D206-547-043

Job No: 196739

Serial No/Batch: S223925

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/18/19

130 Large Fab - Welded Assy-2-B4B	2 pcs	7/26/19	0.00 1.43	Large Fab - 1 - B4B	CZ
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
140 QC 5	2 pcs	7/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12 DAS	
				QC 5 - 17 24	
				QC 5 - 18 9-89	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 QC 10	2 pcs	7/26/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24 DAS	
				QC 10 - 43 24	
				QC 10 - 50 9-89	
				QC 10 - 58	
160 Small Fab - 3 - B4B	2 pcs	7/26/19	0.00 2.14	QC 10 - 9	Smb 19/10/21
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
170 QC 5	2 pcs	7/26/19	0.00 0.00	Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	

180 Powdercoat - 4 Black Sand - 2 B4B 1156440 pcs START: 11:20 A.T. 3:30 P.M. 10:50	7/26/19 0.00 0.16	QC 5 - 40 Powdercoat - 1 - B4B Powdercoat - 2 - B4B Powdercoat - 3 - B4B Powdercoat - 4 - B4B	OCT 2 2 2019
190 QC 3 2 pcs	7/26/19 0.00 0.00	QC 3 - 10 QC 3 - 13 QC 3 - 15 QC 3 - 17 QC 3 - 18 QC 3 - 2 QC 3 - 28 QC 3 - 3 QC 3 - 30 QC 3 - 34 QC 3 - 36 QC 3 - 41 QC 3 - 51 QC 3 - 58 QC 3 - 59 QC 3 - 68 QC 3 - 9 QC 3 - 40 QC 3 - 19 QC 3 - 43 QC 3 - 24	OCT 2 3 2019
200 Packaging 3-1 - Stock - B4B 2 pcs Oscar OCT 2 3 2019	7/26/19 0.00 0.00	Packaging 3 - 1 - B4B Packaging 3 - 2 - B4B Packaging 3 - 3 - B4B Packaging 3 - 4 - B4B Packaging 3 - 5 - B4B Packaging 3 - 6 - B4B Packaging 3 - 7 - B4B Packaging 3 - 8 - B4B Packaging 3 - 9 - B4B Packaging 3 - 10 - B4B Packaging 3 - 11 - B4B Packaging 3 - 12 - B4B Packaging 3 - 13 - B4B Packaging 3 - 14 - B4B Packaging 3 - 15 - B4B Packaging 3 - 16 - B4B Packaging 3 - 17 - B4B Packaging 3 - 18 - B4B Packaging 3 - 19 - B4B Packaging 3 - 20 - B4B Packaging 3 - 21 - B4B Packaging 3 - 22 - B4B Packaging 3 - 23 - B4B Packaging 3 - 24 - B4B Packaging 3 - 25 - B4B Packaging 3 - 26 - B4B Packaging 3 - 27 - B4B Packaging 3 - 28 - B4B Packaging 3 - 29 - B4B Packaging 3 - 30 - B4B Packaging 3 - 31 - B4B Packaging 3 - 32 - B4B Packaging 3 - 33 - B4B	ST 37/

210 QC 21 - FG	2 ✓ pcs	7/26/19	0.00 0.00	Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - FG - 21 ✓	51371
				QC 21 - FG - 70	DAS
				QC 21 - SA - 53	21

OCT 23 2019

Part Op 100 - Small Fab) 1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates
 Descriptions: DT 8264-1, DT 8264-2, DT8264-3, DT8264-4 2-Debur

110 - (Small Fab) 1-Grind weld relief chamfer as per Dwg D206-547 2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

120 - (QC5- Inspect part completeness to step on W/O)

130 - Large Fab 8 (Fabricate per Drwg) 1-Tack weld as per Dwg D206-547 A/R AL ROD Batch: M134785

140 - (QC5- Inspect part completeness to step on W/O)

150 - (QC10- Inspect visual per QSI004- ground welds)

160 - (Small Fab) 1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

170 - (QC5- Inspect part completeness to step on W/O)

180 - Powdercoat4 (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

190 - QC3- Inspect Part Finish)

200 - Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

012477

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MS20470AD3-4	Rivet, Universal Head	40 Ea (20 ea)	100-Small Fab - 1	fm136665-40
D2024	Extrusion (\$ Per Square Foot)	6.8400 ft (3.42 ea)	110-Small Fab - 2 - B4B	5047813
D2602-1	Console Side, 206 Console	2 pcs (1 ea)	110-Small Fab - 2 - B4B	518099
D2602-2	Console Side, 206 Console	2 pcs (1 ea)	110-Small Fab - 2 - B4B	518099
D2606	Console Bracket, 206/407 Console	2 pcs (1 ea)	110-Small Fab - 2 - B4B	518099
D2607	Bracket, 206 Console	2 pcs (1 ea)	110-Small Fab - 2 - B4B	518099
MS20470AD3-3	Rivet, Universal Head	16 Ea (8 ea)	110-Small Fab - 2 - B4B	518099

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	MS20470AD3-4	40	5,396	0
110-Small Fab - 2 - B4B	D2024	7	877	0
	D2602-1	2	0	0
	D2602-2	2	2	0
	D2606	2	1	0
	D2607	2	4	0
	MS20470AD3-3	16	6,039	0

Part Specifications

Specifications could not be found.

Plex 6/20/19 11:18 AM Dart.lajeunesse.marie

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____		DISPOSITION		DEPARTMENT/PROCESS		MRB (QS1042)																													
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐																													
Date: _____		Sequence #: _____		QTY Affected: _____																															
Description Work Order Deviation				Disposition																															
Root Cause		FAULT CATEGORY																																	
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		<table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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		Completed By																																	
		Lead hand / Supervisor																																	
		QC / QA Coordinator																																	